

Date: Thursday, 9/20/2007 3:26:39 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: PANEL		
Job Number	34736			Part Number	: D32591		
Estimate Number	12950			Drawing Number	: D3259 REV A1		
P.O. Number	:			Project Number	: N/A		
This Issue	9/20/2007	S.O. No.	:	Drawing Revision	: A1		
Prsht Rev.	: NC			Material	:		
First Issue	11	Type	SMALL /MED FAB	Due Date	10/10/2007	Qty:	10
Previous Run	34250			Um:	Each		
Written By	<i>John</i> 07-09-20						
Checked & Approved By							
Comment	Est Rev:A New Issue 07-07-19 JLM			Verified By:EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S032	2024-T3 .032 sheet
Comment: Qty.: 1.4574 sf(s)/Unit Total : 5.8296 sf(s) 2024-T3 .032 sheet Batch: <i>M10555</i> <i>B07-09-27</i>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3259 Dwg Rev: <i>A1</i> <i>B07-09-27</i> Prog Rev: <i>A1</i>		
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<i>B07-09-27</i>		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
<i>Fr 07/10/01</i> <i>x10</i> <i>counter</i>		
Comment: SECOND CHECK		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
<i>BL 07-10-02</i>		
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/20/2007 3:26:39 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 34736

Part Number: D32591

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST176

LO 7/1/02 (10)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



07.10.03
07/10/03

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 8/18/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34736
Description: Panel	Part Number:	D3259-1
Inspection Dwg: D3259	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>EB</u>	Audited by: <u>SN</u>	Prototype Approval: N/A
Date: <u>07-09-27</u>	Date: <u>07/10/61</u>	Date: N/A

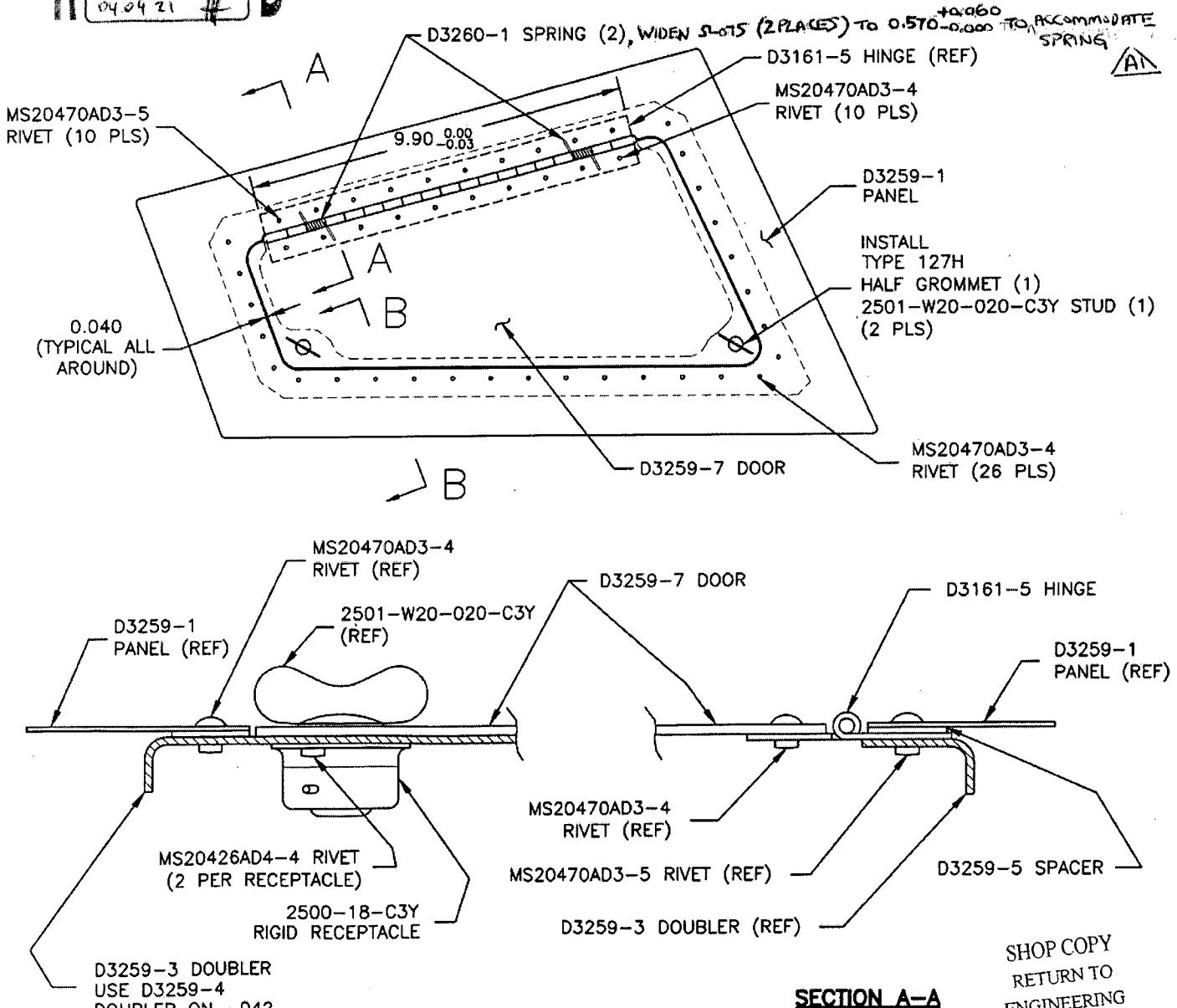
Rev	Date	Change	Revised by	Approved
A	04.08.25	New Issue	P/O D412-705-019	KJ/JLM <i>[Signature]</i> <i>[Signature]</i>

DARTCOPY ISSUED
140

DESIGN RF	DRAWN BY <i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>JP</i>	APPROVED <i>JP</i>	DRAWING NO. D3259
DATE 04.02.25		REV. A SHEET 1 OF 6
		TITLE SCALE ACCESS PANEL ASSEMBLY 1:4
A	04.02.25	NEW ISSUE
A1	04.08.11	WIDEN SLOTS TO ALLOW OPERATION OF SPRING

RELEASED

04.04.21



SECTION A-A
VIEW ROTATED

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NO. 34736

D3259-041 ACCESS PANEL ASSEMBLY (SHOWN)
D3259-042 ACCESS PANEL ASSEMBLY (OPPOSITE)

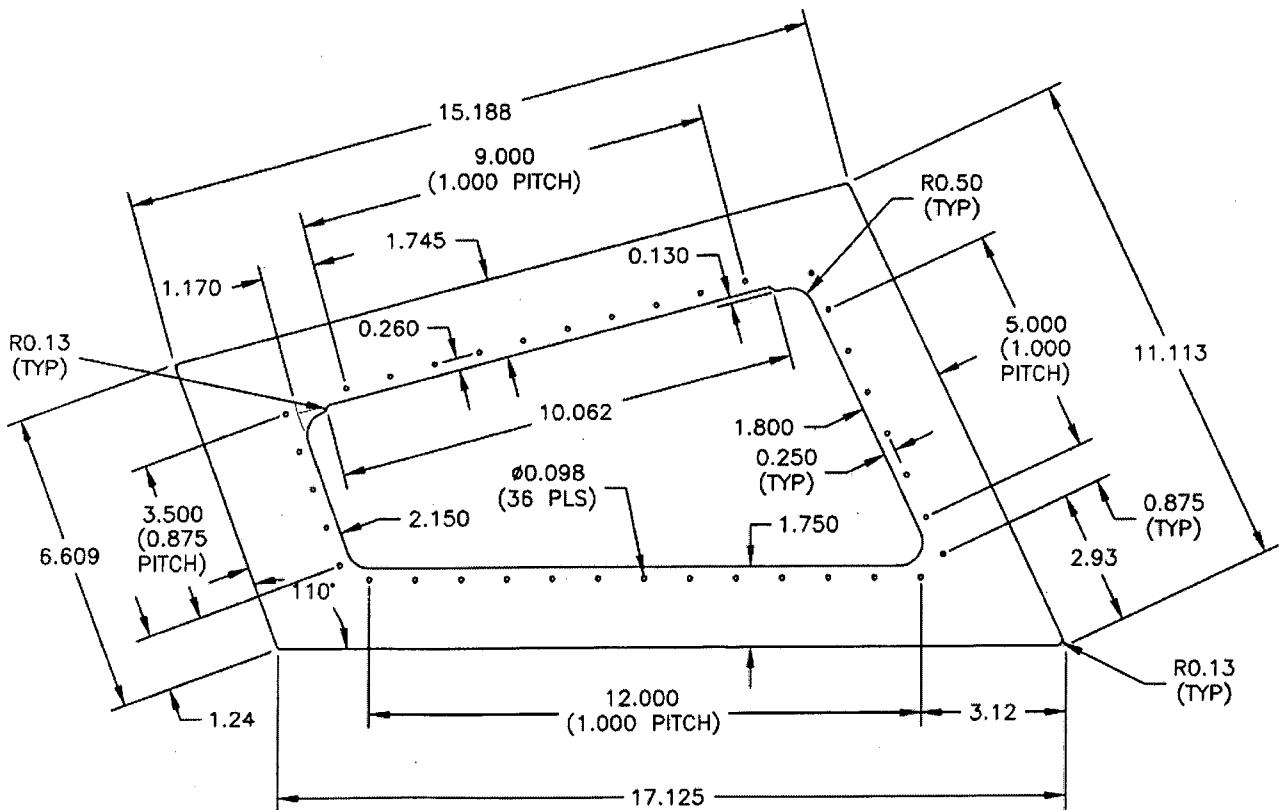
- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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6/6/05

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
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DATE		REV. A SHEET 2 OF 6 TITLE ACCESS PANEL ASSEMBLY SCALE 1:4

RELEASED
04.04.05**D3259-1 PANEL**NOTES:

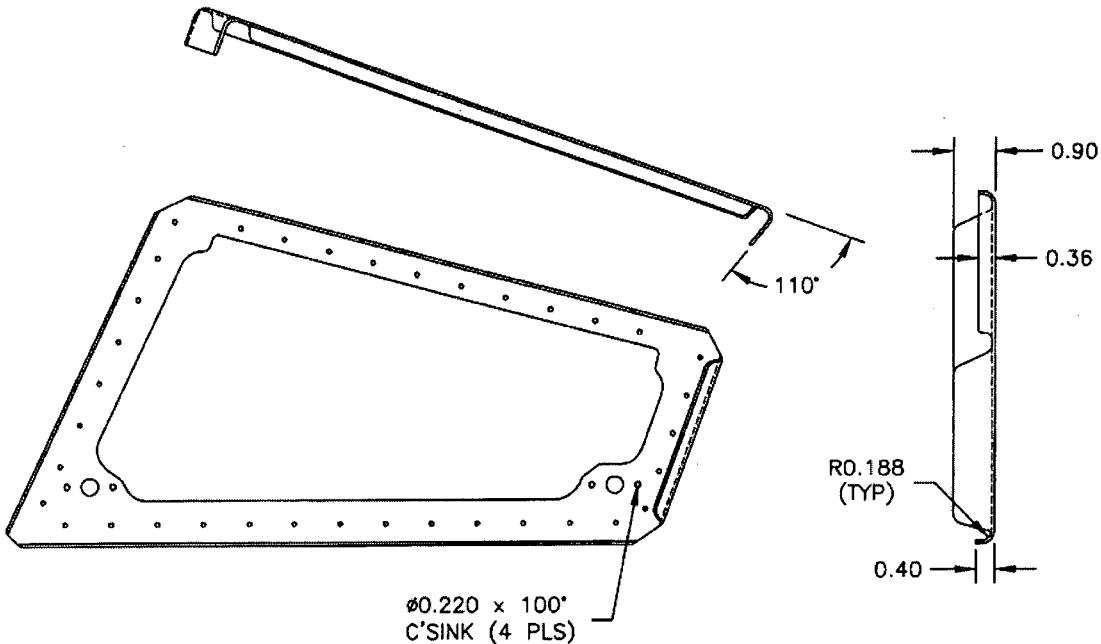
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.14 *PF***D3259-3 DOUBLER BEND DETAIL (SHOWN)**

BEND D3259-4 DOUBLER (OPPOSITE)

D3259-3/-4 NOTES:

- 1) MANUFACTURE PER "D2359-A4.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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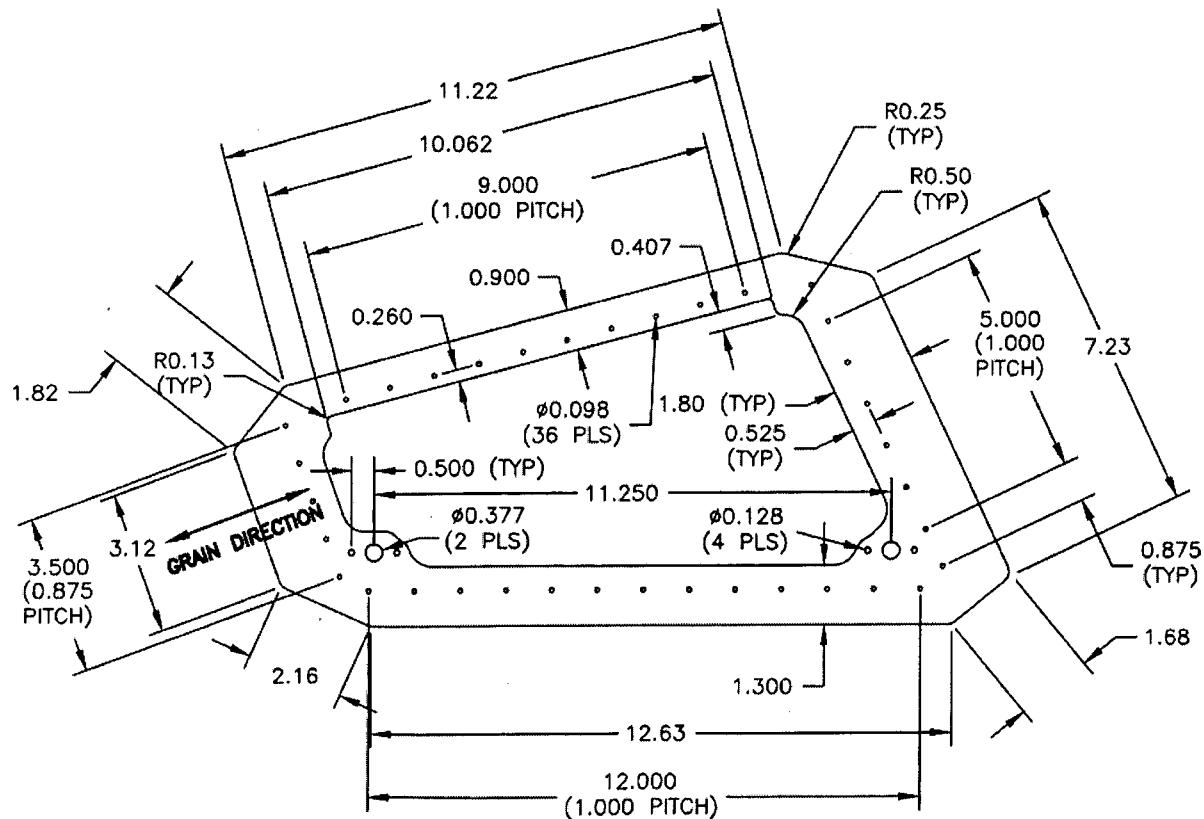
WORK ORDER
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		D3259	SHEET 4 OF 6
DATE		TITLE	SCALE
04.02.25		ACCESS PANEL ASSEMBLY	1:4

RELEASED
04.04.14 *CH*

D3259-3/-4 DOUBLER FLAT PATTERN
($\varnothing 0.098$ HOLES TO COINCIDE WITH HOLES IN D3259-1)

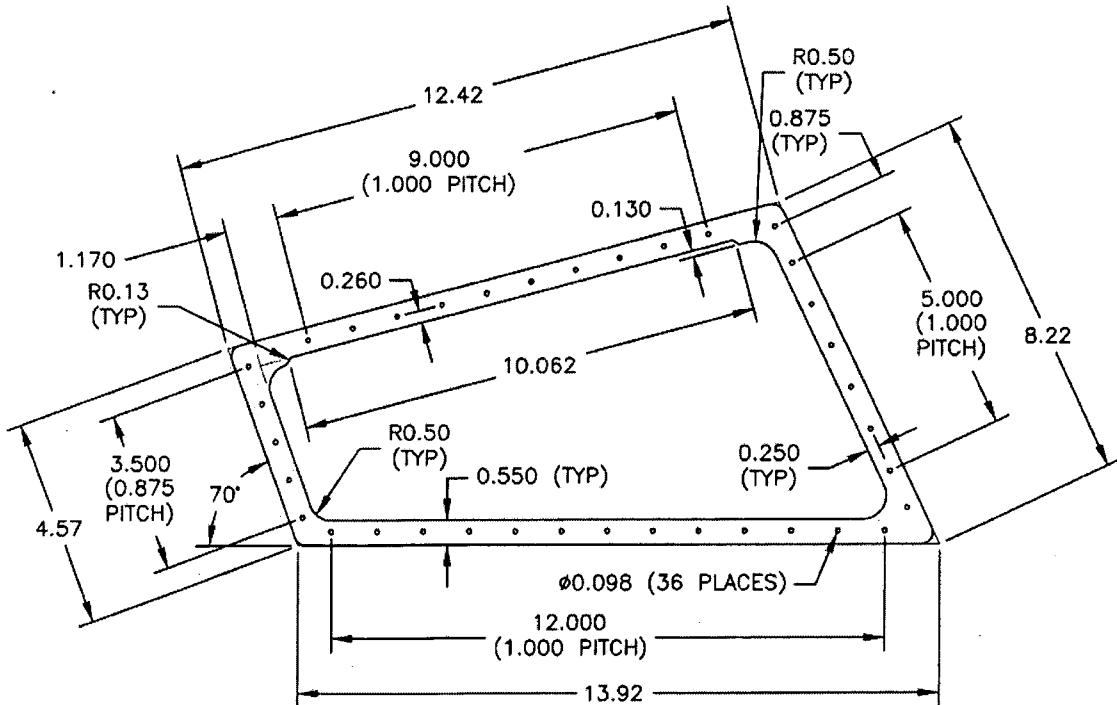
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SHEET 5 OF 6

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RELEASED
04.04.05**D3259-5 SPACER**

(.0098 HOLES TO COINCIDE WITH HOLES IN D3259-1)

NOTES:

- 1) MANUFACTURE PER "D3259-A5.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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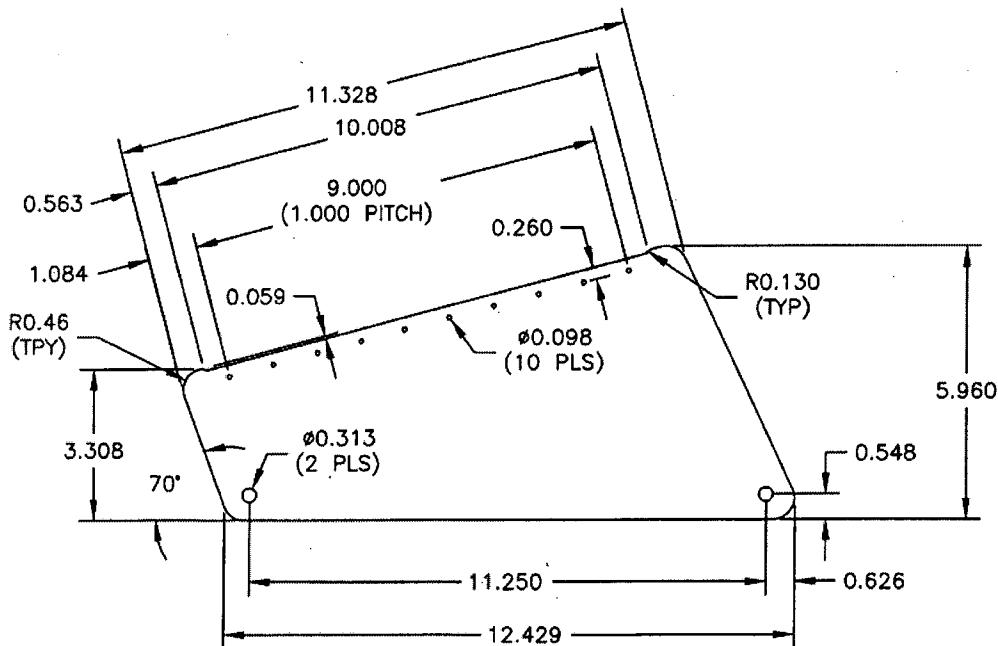
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DATE 04.02.25	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:4	

RE-RELEASED
04.04.14 



D3259-7 DOOR

NOTES:

- 1) MANUFACTURE PER "D3259-A6.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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